



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT400313-1
Job Sheet 176935



Part No: RBT400313-1

Job Qty: 7 ea

Part Name: Adapter Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/18/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT400313 Rev 1 IPP Rev A 18.02.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	7 Ea		5/18/18	0.00	0.00	Start Up Machining-2		<i>EL</i>
140	Large Fab	7 pcs		5/18/18	0.00	2.33	Large Fab 3		<i>EL</i>
150	QC	7 pcs		5/18/18	0.00	0.00	QC9		<i>PD 1805-10</i>
190	Outsource	7 pcs		5/18/18	0.00	0.00	Outsource12		<i>CT 18-5-10</i>
200	Packaging	7 pcs		5/18/18	0.00	0.00	Packaging2		<i>A 1805/18</i>
210	QC	7 pcs		5/18/18	0.00	0.00	QC6		<i>MAY 18 2018</i>
220	Packaging	7 pcs		5/18/18	0.00	0.00	Packaging3		<i>18-05-22 GA 136</i>
230	QC21-SA	7 Ea		5/18/18	0.00	0.00	QC21		<i>MAY 22 2018</i>

At 1805/18

Part Op 140 - Weld as per DWG sheet 2. Align -3 to -5 using half inch hardware. End of -11 pin must be on center line.
Descriptions: 190 - Issue P/O to Groupe Altech; PO *039867* - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400313-3	Plate	7 Ea (1 ea)	90-Start up Operation	<i>5049784</i>
RBT400313-5	Adapter	7 Ea (1 ea)	90-Start up Operation	<i>5069548</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBT400313-3	7	7	0
	RBT400313-5	7	0	0

Part Specifications

Specifications could not be found.

Plex 5/3/18 10:07 AM Dart.lajeunesse.marie



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

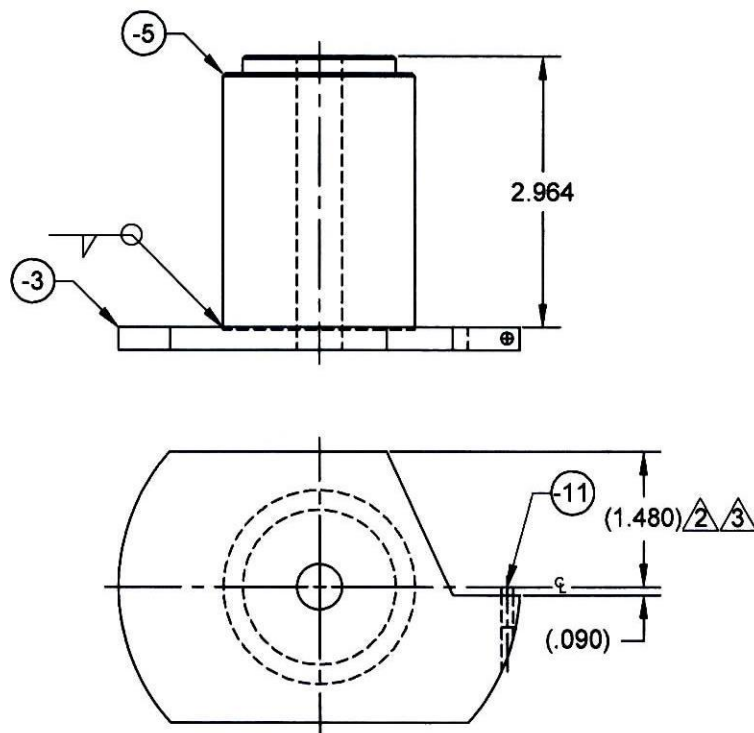
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CORRECTED -1 VIEW ADDED MISSING LINES, MOVED NOTE 2 TO -17 & CORRECTED NOTE 1.	5/16/12	RJC	SE
1	-1 ADDED REF. DIMS AND NOTES.	5/12/14	DPD	GE



NOTES:

1. ALIGN -3 TO -5 USING 1/2" HARDWARE.
2. END OF PIN (-11) MUST BE ON CENTERLINE.
3. MILL -11 HEIGHT TO MEET .090 AFTER ASSY.

-1
ADAPTER WELDMENT

RED BARN MACHINE	
TITLE MAIN XSMN BACKLASH TOOL	
DWG NO. RBT400313-1	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS
XXX ± .005	1/32
XX ± .01	ANGLES ± .5°
X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH	
APPROVED: <i>D. Wed</i>	
HEAT TREAT	
FINISH: BLACK OXIDE	
SPEC	
USED ON MODEL	
BELL 204, 205, 212	
SCALE: 1:2	DATE: 1-7-11
SHEET: 2 of 6	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube Small Fab ☐ Water Jet Prod. Eng. Coord. ☐ Engineering Quality Other ☐ Per/Store/Packaging ☐ Approval ☐					
Date : _____		Step #: _____		DART AEROSPACE Container No: S069666 Part: RBT400313-1 Job No: 176935 Serial No/Batch: S069666 Revision: 1 Inspector: _____ 1270 Abercrombie Street Hertfordshire, UK SG4 1K7 TEL: +44 (0)1438 820000 Email: sales@dartaero.com www.dartaerospace.com					
Description Work Order Deviation									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Force ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Used Wrong ☐ Dimensions ☐ Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039867**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039867
PO Date: 5/10/18
Due Date: 5/18/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176935	RBT400313-1	Adapter Weldment -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	5/18/18	7 pcs	0 pcs <i>✓ 7x</i>	7 pcs	\$17.1428571/pcs <i>A1805/18</i>	\$120.00
Grand Total:										\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CT.

DAS
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89

Plex 5/17/18 9:47 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(009249-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009249 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
17-May-2018		Aman			PO039867				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	RBT400313-1 Rev.	RBT400313-1 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0	0	0	0

DAS
11
9-89

MAY 18 2018

Notes Additionnelles / Additional Notes

1 Box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.